



Container No: S084382



Part: RB23006764

Job No: 179770

Serial No/Batch: S084382

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/18

RECEIVED

HTUA

DATE

3100



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB23006764

Job Sheet 179770



Part No: RB23006764

Job Qty: 6 ea

Part Name: Gage Retaining Ring



Part Weight: 0 lbs

Job Created: 6/21/18

Due Date: 7/3/18

Type: SOLD

Status: Scheduled

Job Tracking No:

Created By: Logan David

Description:

Note: DWG RB23006764 Rev.0 IPP Rev. A 18.05.28 new issue DP Verify DD

Ship Via:

Priority: High

POSITIVE RECALL

EFFECTIVE 18/6/18 AUTH 5

RELEASED 5 DATE 18/6/18

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Machining-3		18/06/18
100	Waterjet	6 pcs	7/3/18	7/3/18	0.00	0.60	Waterjet 2 OMAX		18/06/18
110	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Waterjet-4		18/06/18
111	Mill Conv	6 pcs	7/3/18	7/3/18	0.00	3.00	Mill Conv 1		18/07/18
112	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Machining-5		18/07/18
130	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC8		18/07/18
135	Outsource	6 pcs	7/3/18	7/3/18	0.00	0.00	Outsource1		18/07/18
140	Outsource	6 pcs	7/3/18	7/3/18	0.00	0.00	Outsource12		18/07/18
150	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging2		18/07/18
160	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC6		18/07/18
210	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging3-1		18/07/18
220	QC21-FG	6 Ea	7/3/18	7/3/18	0.00	0.00	QC21		18/07/18

Part Op 100 - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ (RED BARN folder) 2-Deburr if necessary
Descriptions: 111 - 1-Machine as per DWG. 2-Deburr

130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

ATLANTIC 135 - 1-Issue P/O to METCORE, P/O 18040507 RC 48-52 2-Bead blast 3-Material type; O1 Steel 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***
140 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 Steel -Certificate of Conformity is required.

MT-01-B-0.250X3.000
S079414

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-B-0.250X3.000	Tool Steel Bar 0.250" X 3.000"	.4800 ft (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-B-0.250X3.000	0	12	0

Part Specifications

Specifications could not be found.

Plex 6/21/18 9:36 AM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB23006764

Job Sheet 178382



Part No: RB23006764

Job Qty: 6 ea

Part Name: Gage Retaining Ring



Part Weight: 0 lbs

Job Created: 5/30/18

Due Date: 7/3/18

Type: SOLD

Status: Scheduled

Priority: High

Job Tracking No:

Created By: Logan David

Description:

Note: DWG RB23006764 Rev.0 IPP Rev. A 18.05.28 new issue DP Verify DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Machining-3		
100	Waterjet	6 pcs	7/3/18	7/3/18	0.00	0.60	Waterjet 2 OMAX		
110	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Waterjet-4		
130	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC8		
135	Outsource	6 pcs	7/3/18	7/3/18	0.00	0.00	Outsource1		
140	Outsource	6 pcs	7/3/18	7/3/18	0.00	0.00	Outsource12		
150	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging2		
160	QC	6 pcs	7/3/18	7/3/18	0.00	0.00	QC6		
210	Packaging	6 pcs	7/3/18	7/3/18	0.00	0.00	Packaging3-1		
220	QC21-FG	6 Ea	7/3/18	7/3/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ (RED BARN folder) 2-Deburr if necessary
 Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 135 - 1-Issue P/O to METCORE; P/O _____ RC _____ 2-Bead blast 3-Material type; O1 Steel 4-
 Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***
 140 - 1-Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer
 of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe
 off excess. -Material type; O1 Steel -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-B-0.250X3.000	Tool Steel Bar 0.250" X 3.000"	.4800 ft (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-B-0.250X3.000	0	12	0

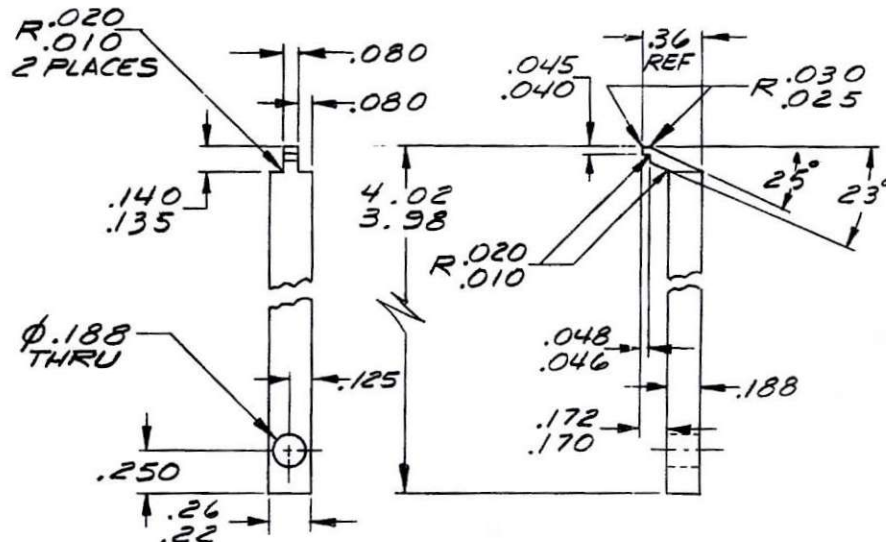
Part Specifications

Specifications could not be found.

Plex 6/15/18 3:44 PM dart.logan.david

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **178382**

20180619



REVISIONS					
LTR	DESCRIPTION	DATE	AUTHORITY	DR	CK

This data is furnished with the understanding that it will be used for Service, Maintenance and Overhaul purposes only and not to Manufacture or procure the Manufacture of the part(s) shown and/or described. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of the Detroit Diesel Allison Division of GMC.

COMPRESSOR ASSY (REF)

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH THE 3/16 HIGH FIGURES THE FOLLOWING
a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
b) VENDOR NAME OR TRADEMARK

FILE COPY

AMS2485
SAE 01
LOCAL SPECS. (REF)

DRAWING PRACTICE		SPEC. SUMMARY	
SURFACE TEXTURE			
SCREW THREADS			
GENERAL SPECIFICATIONS			
TITLE GAGE RETAINING RING, SAG			
MODEL 23006764, C30, L.M.R.S.		APPLICATION: SEE SEPARATE PARTS LIST	
SIZE C	FSCM No. 73342	DWG. No. 23006764	
SCALE 2/1		SHEET	

GEOMETRIC CHARACTERISTIC SYMBOLS			
FLATNESS	ANGULARITY	OR MMC (MAX MATL. CONDITION)	
STRAIGHTNESS	RUNOUT	OR RFS (REGARDLESS OF FEATURE SIZE)	
ROUNDNESS	TRUE POSITION	PROJECTED TOL. ZONE	
CYLINDRICITY	CONCENTRICITY	DATUM TARGET	
PROFILE OF A LINE	SYMMETRY		
PROFILE OF A SURFACE	BASIC DIM.		
PERPENDICULARITY	DIAMETER		
PARALLELISM	DATUM IDENT		

UNLESS OTHERWISE SPECIFIED:
ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC.
ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS.
SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE.
RUNOUTS ARE CIRCULAR.

BREAK SHARP EDGES .020 UOS	
UNLESS OTHERWISE SPECIFIED TOL. ON ANGLES $\pm 1^\circ$ TOL. ON DECIMALS $\pm .010$	
MATL. SAE 01	DRAWING DATE 82-4-22 DRAFTSMAN BARRETT/SH CHECKER 5. BARRON/SH APPROVED JD Perry METALLURGY ENGR 1 R. GRISWOLD ENGR 2
HEAT TREAT AND HARDNESS Rc 48-52	FINAL E.J. REAGAN WELD OR BRAZE
SURFACE TREAT AMS 2485 (BLACK OXIDE)	INSPECTION

IF PURCHASED SEPARATELY
MUST BE STAMPED OR ETCHED WITH
TOOL NUMBER AND DETAIL NUMBER
IF AVAILABLE, ATTACH TAG

DWG NO. 23006764

~~178382~~



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040536**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040536
PO Date: 7/18/18
Due Date: 7/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179770	RB23006764	Gage Retaining Ring -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 Steel -Certificate of Conformity is required	Firmed	-	7/23/18	7 pcs	0 pcs	7 pcs	\$17.1428571/pcs	\$120.00

FX 1818-07-26

Grand Total: \$120.00

Order Notes

CE

Order Notes**Procurement Quality Clauses**

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/18 11:30 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(011182-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011182 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Jul-2018		Aman		040536				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB23006764 Rev.	RB23006764 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK MIN-CHG	7	7	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 lité financière et légale ne sera pas supérieure au montant de la facture issue.

that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 legal responsibility will not be higher than the amount of invoice.

Certification

Date: 07/18/2018

Entry Date: 07/17/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO040507

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
7	7pcs Material 01 Sand blast and Heat treat to 48-52 C of C	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
------------	-------	---------	---------	--------	-------

Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 48. 52. 48. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 48 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY) ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER, THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.



KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD